

Dart Aerospace Ltd.

Date: Wednesday, 4/5/2006 8:23:55 PM
 User: Kim Johnson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : VERTICAL REFERENCE DOOR ASSEMBLY
 Job Number : 26543
 Estimate Number : 10902
 P.O. Number : N/A Part Number : D412711041
 This Issue : 4/5/2006 S.O. No. : N/A Drawing Number : N/A
 Print Rev. : NC Project Number : N/A
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : N/A
 Previous Run : 26542 Material : N/A
 Due Date : 4/21/2006 Qty: 1 Um: Each
 Written By : SEE COMMENT BELOW
 Checked & Approved By : AF 06.04.06
 Comment : Est Rev: A 04.08.18 New Issue KJ/DS

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 978 to Eagle Copters

"Assembly of D412-711-041 Door Assembly in accordance with Dart IPP D412-711-041"

Send a copy of this IPP

06/04/10

①

2.0

D412711041

Vertical Ref. Door Assy



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Vertical Ref. Door Assy

3.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

EAGLE

Pick: Qty Part Number Description Batch

1 204-030-853-119 LH Co-pilot Door 42558

Attach serviceable tags

2- EAGLE

Fabricate/Pick the following parts to go into the door in accordance with:

D2046902 Sheet

1 Rev. 3

D2046902 Sheet 2 Rev. 2

D2046902 Sheet 3 Rev. 0

D2046901 Sheet 3 Rev. 1

Qty Part Number Description Batch

1 EB212-100L / EA20469-3 Window 06-0070841 EA20469-05 Rubber Strip 05-002898

Date: Wednesday, 4/5/2006 3:23:55 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 26543

Part Number: D412711041

Job Number:



Seq. #:

Machine Or Operation:

Description:

- | | | | |
|---|------------|------------------|------------|
| 1 | EA20469-06 | Aluminum Strip | W.O. 40359 |
| 1 | EA20469-07 | Angle | W.O. 40359 |
| 1 | EA20469-08 | Placard | W.O. 40359 |
| 1 | EA20469-10 | Rear Rib Assy | W.O. 40359 |
| 1 | EA20469-11 | Angle | W.O. 40359 |
| 1 | EA20469-12 | Fwd Rib | W.O. 40359 |
| 1 | EA20469-13 | Window | W.O. 40359 |
| 1 | EA20469-14 | Window Retainer | W.O. 40359 |
| 1 | EA20469-16 | Armrest Assy | W.O. 40359 |
| 1 | EA20469-17 | Angle | W.O. 40359 |
| 1 | EA20469-18 | Door Inner Skin | W.O. 40359 |
| 1 | EA20469-21 | Door Cover Panel | W.O. 40359 |
| 2 | EA20469-23 | Link | W.O. 40359 |
| 1 | EA20469-24 | Rod | W.O. 40359 |
| 1 | EA20469-25 | Arm Assy | W.O. 40359 |

Material Certification / Proof of Traceability / Certificate of Conformity required

3-EAGLE

Pick:

Qty Part Number Description Batch

- | | | |
|-----|----------------------|------------|
| 14 | AN3-3ABolt | W.O. 40359 |
| 22 | AN3-4ABolt | W.O. 40359 |
| 24 | AN3-7ABolt | W.O. 40359 |
| 6 | AN960-6L Washer | W.O. 40359 |
| 90 | AN960-10L Washer | W.O. 40359 |
| 34 | CR3242-4-2 Rivet | W.O. 40359 |
| 135 | MS20426AD3-3 Rivet | W.O. 40359 |
| 140 | MS20426AD4-3 Rivet | W.O. 40359 |
| 25 | MS20470AD3-3 Rivet | W.O. 40359 |
| 90 | MS20470AD4-3 Rivet | W.O. 40359 |
| 24 | MS21042L3 Nut | W.O. 40359 |
| 2 | MS21042L06 Nut | W.O. 40359 |
| 13 | MS21069L3 Nut Plate | W.O. 40359 |
| 8 | MS21069L08 Nut Plate | W.O. 40359 |
| 1 | MS21071L3 Nut Plate | W.O. 40359 |
| 1 | MS21071L08 Nut Plate | W.O. 40359 |
| 9 | MS21075L3 Nut Plate | W.O. 40359 |
| 2 | MS24677-12 Screw | W.O. 40359 |
| 6 | MS27039-1-09 Screw | W.O. 40359 |

4-Assemble door in accordance with: D2046901 Sheet 2 Rev. 5 D2046901 Sheet 7 Rev. 5 Do not install
 EA20469-15 or wiring harness at this time.

Date: Wednesday, 4/5/2006 3:23:55 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 26543

Part Number: D412711041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5-Apply Dart P/N & B/N using fine point permanent marker

4.0

QC4/5

INSPECT 100% KITS FOR COMPLETENESS



Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS
Send this W/O back to DartKit to be stocked at Eagle

J. Road

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location:

N/A Stocked at Eagle

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

SD 06/05/18

Job Completion

*W 06-05-18*

DART**Purchase Order**

Date Apr 10, 2006	Page 1
Purchase Order Number PO00000978	

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053


Vendor Address:

Eagle Copters Maintenance Ltd.
823 McTavish Road
Calgary, AB T2E 7G9
Canada
Phone (403) 250-7370
Fax (403) 250-7110

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-EAG002	Apr 10, 2006	N30		Apr 28, 2006

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
1.0000	D412-711-041	Vertical Ref. Door Assy Comments: ASSEMBLY OF D412-711-041 DOOR ASSEMBLY IN ACCORDANCE WITH DART IPP D412-711-041 B26543	4/28/2006	No	900.000000	Each	900.00
Comments:		Tax Summary:		Less:			
		GST		63.00		Included tax	
		GSTME		0.00			
		GSTND		0.00			
		Entered By: CZ		APROVEN		Subtotal	
		Approved By: 				Total tax	
						Total purchase order in	
						CAD Dollars	

Date: Wednesday, 4/5/2006 3:23:55 PM
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Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	VERTICAL REFERENCE DOOR ASSEMBLY	
Job Number :	26543	Part Number :	D412711041	
Estimate Number :	10902	Drawing Number :	N/A	
P.O. Number :		Project Number :	N/A	
This Issue :	4/5/2006	S.O. No. :		
Prsht Rev. :	NC	Drawing Revision :	N/A	
First Issue :	//	Type :	PURCHASED PARTS	
Previous Run :	26542	Material :	N/A	
Written By :		Due Date :	4/21/2006	Qty: 1 Um: Each
Checked & Approved By :	<i>[Signature]</i> 06.04.06			
Comment :	Est Rev:A 04.08.18 New Issue KJ/DS			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0

PG

PURCHASING

**Comment:** PURCHASINGIssue P/O: 978 to Eagle Copters

"Assembly of D412-711-041 Door Assembly in accordance with Dart IPP D412-711-041"

Send a copy of this IPP

C206104110 ①

2.0

D412711041

Vertical Ref. Door Assy

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Vertical Ref. Door Assy

3.0

OUTSIDE SERVICE

OUTSIDE SERVICES

**Comment:** Sub-Contracting OUTSIDE SERVICES

EAGLE

Pick:Qty Part Number Description Batch

1 204-030-853-119 LH Co-pilot Door

Attach serviceable tags

2- EAGLE

Fabricate/Pick the following parts to go into the door in accordance with:

D2046902 Sheet

1 Rev. 3

D2046902 Sheet 2 Rev. 2

D2046902 Sheet 3 Rev. 0

D2046901 Sheet 3 Rev. 1

Qty Part Number Description Batch

1 EB212-100L / EA20469-3 Window

1 EA20469-05 Rubber Strip

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 26543

Part Number: D412711041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1	EA20469-06	Aluminum Strip _____
1	EA20469-07	Angle _____
1	EA20469-08	Placard _____
1	EA20469-10	Rear Rib Assy _____
1	EA20469-11	Angle _____
1	EA20469-12	Fwd Rib _____
1	EA20469-13	Window _____
1	EA20469-14	Window Retainer _____
1	EA20469-16	Armrest Assy _____
1	EA20469-17	Angle _____
1	EA20469-18	Door Inner Skin _____
1	EA20469-21	Door Cover Panel _____
2	EA20469-23	Link _____
1	EA20469-24	Rod _____
1	EA20469-25	Arm Assy _____

Material Certification / Proof of Traceability / Certificate of Conformity required

3-EAGLE

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

14	AN3-3ABolt	_____	_____
22	AN3-4ABolt	_____	_____
24	AN3-7ABolt	_____	_____
6	AN960-6L Washer	_____	_____
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34	CR3242-4-2 Rivet	_____	_____
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90	MS20470AD4-3 Rivet	_____	_____
24	MS21042L3 Nut	_____	_____
2	MS21042L06 Nut	_____	_____
13	MS21069L3 Nut Plate	_____	_____
8	MS21069L08 Nut Plate	_____	_____
1	MS21071L3 Nut Plate	_____	_____
1	MS21071L08 Nut Plate	_____	_____
9	MS21075L3 Nut Plate	_____	_____
2	MS24677-12 Screw	_____	_____
6	MS27039-1-09 Screw	_____	_____

4-Assemble door in accordance with : D2046901 Sheet 2 Rev. 5 D2046901 Sheet 1 Rev. 5 Do not install
EA20469-15 or wiring harness at this time.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 26543

Part Number: D412711041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5-Apply Dart P/N & B/N using fine point permanent marker

4.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS

Send this W/O back to DartKit to be stocked at Eagle

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/05/18

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries